120

QC2- Inspect parts off machine FAI/FAIB

0.00

1.20

QC

Memo

0.00

B11-12-12

Quality Control

Dart Ae	rospace	e <u>L</u> td				. –			_ • - , -
W/O:			WC	ORK ORDER CHANGES	3				
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
Dowt No.		DAD #	Fault Oata		NCD: Voc	, 	204	Dato	
Part No		PAR #: esolution:							
NCR:	-	V	VORK ORDI	ER NON-CONFORMAN	ICE (NCI	R)			
		Description of NC		Corrective Action Section		Vei	rification	Approval	Approva
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& S	ection C	Chief Eng	QC Inspecto
. 1									

Work Ord November-22-1					*76	859*				,			Page 2	
Item ID: Revision ID: Item Name:	D3243-041 Bracket Asser	mbly			Accept	*N900	040	100)*	Setup	Start Stop	I VI	S1*	
Start Date: Required Date Reference:	22/11/2011	Start Qty: 6.00 Req'd Qty: 6.00		*6* *6*		Cust Item I Customer:	D:				ctop	^INI	S2*	
Approvals:		ın:			0	D	ate:			Run	Start Stop	171	R1*	
	QC:		Date:		SPC (Y/N):	D:	ate:				этор	*N	R2*	
Sequence ID/ Work Center I	D	Operation Description			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Rej Qty		Reject Number	Insp. Stamp	
*130 *130* QC Quality Control		QC8- Inspect parts - seco	ond check		0.00	lizliz			46					
150 *150* Brake NC Brake NC		NC BRAKE Memo Form as per	Dwg D3243		0.00	is ululo			_ 5	ત	· ~			PT
*160 *160*		QC5- Inspect part comple	eteness to step	on W/O	0.00	1170			4)	>				
QC		Memo			0.00	1 *								

Quality Control

Dart Aeı	rospace	e_Ltd						_ ,_ ,_
w/o: 76	859		V	ORK ORDER CHANGES	S			
DATE	STEP	PROC	EDURE CH		Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector
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	:							1
Part No:	D#	3243-04 PAR #:	_ Fault Ca	tegory: Small Faiz	NCR: Yes	No DQA	Date: //	2/01/03
11.	R	esolution: SCAP	_ Disposit		QA: N/C Clo	. /		2/01/03
NCR:	1000	W	ORK OR	DER NON-CONFORMAN	ICE (NCR) 33.71		
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	B Sign & Date	Verification Section C	Approval Chief Eng	Approval QC inspecto
11/12/20	150	pier at the forming was out	S	Sergo, destr	es Sh	S	5	
' '		of roterance of	المحارات		1	111 (7) 20		

			Description of NC	Corrective Action Section B				Approval	Approval	
	DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Chief Eng	QC inspector	
	ululo	150	forming was out, of toterance at the set up	11/17/20	Sergo, destroy	S1 11/1/20	5 412/20	U112/20 QSZ04Z	11/12/70	
			R.C Process	031				80		
	•) (
:										

Work Order ID 76859 *76859* Page 3 November-22-11 10:56:04 AM D3243-041 Item ID: Accept *N900040100* Setup Start **Revision ID:** Item Name: Bracket Assembly **Start Date:** 22/11/2011 Start Oty: 6.00 **Cust Item ID:** Required Date: 06/12/2011 **Req'd Qty:** 6.00 **Customer:** Reference: Run Start Process Plan: **Tooling:** Approvals: Date: Date: Stop Date:____ SPC (Y/N): QC: Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Reject Plan Accept Reject Insp. **Work Center ID Description** Code Oty Number Stamp **Run Hours Oty** 170 Chemical Conversion Coat per QSI005 4.1 0.00 *170* HandFinish 0.00 Memo Hand Finishing 180 0.00 Small Fab *120* Small Fab 0.00 Memo Small Fab Install Inserts as per Dwg D3343

190

190 QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

Dart Ae	rospace	e Ltd						3
W/O:			W	ORK ORDER CHANGES				
DATE	STEP	PROC	CEDURE CHA		Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector
		·						
· · · · · · · · · · · · · · · · · · ·								
Part No	:	PAR #:	_ Fault Cate	egory: N	CR: Yes	No DQA :	Date: _	
	R	esolution:	_ Disposition	on: Q	A: N/C CI	osed:	Date: _	
NCR:		W	ORK ORD	DER NON-CONFORMANO	E (NCR)		
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section B Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC inspecto

Work Orde			~ ~	*768	359*		Page 4
Revision ID:	D3243-041 Bracket Assen	nbly		Accept	*N90004010		tart *NS1* top *NS2*
Start Date: Required Date: Reference:	22/11/2011 06/12/2011	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item ID: Customer:		IVIO
Approvals:	Process Pla	in:	Date:	Tooling: SPC (Y/N):	Date:		*NR1* *NP2*
Sequence ID/ Work Center ID 200 *200* Powdercoat Powder Coating		Operation Description Black Sandtex(Ref:4.3.5 Memo *****Mask START TIM OVEN TEM FINISH TIM	Holes***** JE: IPERATURE:	Set Up/ Run Hours 0.00	Tool ID Tool # Plan Code	Accept Reject Qty Qty	Reject Insp. Number Stamp
*210 *210* QC Quality Control		QC3- Inspect Part Finish Memo	·	0.00		6 BL 11	1-12- 2 1.
220 *20 *20 *20 Packaging Packaging		Identify as per dwg & Sto	ock Location: 227	0.00		11/12/2	(Z) (Z)

Dart Ae	rospace	Ltd						,
W/O:			WC	RK ORDER CHANGE	S			
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date Qt	Approval Chief Eng / Prod Mgr	Approva QC Inspector
Part No);	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA:	Date: _	
	Re	esolution:	Disposition	1:	QA: N/C C	losed:	Date: _	
NCR:			WORK ORD	ER NON-CONFORMAN	ICE (NCF	₹)		
		Description of NC		Corrective Action Section		Verification	n Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign and Date	& Section C	Chief Eng	QC Inspecto
		-						
1						1		

Work Ord November-22-1				*768	359*							Page 5
Item ID: Revision ID: Item Name:	D3243-041 Bracket Assen	nbly		Accept	*N900	040	100)*	Setup	Start Stop	IA	S1* S2*
Start Date: Required Date Reference:	22/11/2011 : 06/12/2011	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item II Customer:	D:						
Approvals:	Process Pla	n:	Date:	Tooling:	Da	te:			Run	Start	*N	R1*
	QC:		Date:	SPC (Y/N):	Da	te:				Stop	*N	R2*
Sequence ID/ Work Center I 230 *230* QC Quality Control	D	Operation Description QC21- Final Inspection -	Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	t Re Qt	-	Reject Number	Insp. Stamp

mr -22

Dart Aerospace Ltd WORK ORDER CHANGES W/O: **Approval Approval** DATE STEP PROCEDURE CHANGE By Date Qty Chief Eng / QC Inspector Prod Mgr Part No: ______ PAR #: ____ Fault Category: _____ NCR: Yes No DQA: ____ Date: ____ Resolution: _____ Disposition: _____ QA: N/C Closed: ____ Date: ____ **WORK ORDER NON-CONFORMANCE (NCR)** NCR: **Corrective Action** Section B **Description of NC** Verification **Approval Approval** DATE **STEP Action Description** Sign & Initial Section A Section C Chief Eng QC Inspector Date Chief Eng Chief Eng

Picklist Print

November-22-11 10:56:08 AM

Work Order ID: 76859

76859

Parent Item:

D3243-041

D3243-041

Parent Item Name: Bracket Assembly

Start Date: 22/11/2011

Required Date: 06/12/2011

Page 1

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:A New Issue

Purchased

05-11-29 JLM

No

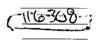
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	
M6061T6S.063		Purchased	No			110	sf	163.8656	0.5499	3.473053	-			
M6061T6	S 063								**		311-12	- 12		

6061-T6.063 Sheet

Location	Le	oc Qty	Loc Code
MAT021	163.8	655684	
116308	23.9	555684	
117285		88.91	
119331		51	
	180	Each	270.0000

FE-032-EF

Location	Loc Qty	Loc Code
ST285	270	
110836	14	
117168	156	
117226	100	



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Dart Aerospace Ltd

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W/O:		- We did to		RK ORDER CHANG	GES						
DATE	STEP	PRO	OCEDURE CHA	NGE	В	By Date Qt			Approval Chief Eng / Prod Mgr	Approval QC Inspector	
							-				
Part No:		PAR #:	Fault Cate	gory:	NCR: \	es N	No DQA: Date:				
Resolution:			Disposition: Q			N/C Closed: Date:				·	
NCR:			WORK ORDI	R NON-CONFORM	IANCE (N	ICR)					
DATE	0750	Description of NC	Corrective Action Section				Verification		Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		gn & Date	Secti		Chief Eng	QC Inspector	

DART AEROSPACE LTD	Work Order:	76859
Description: Bracket	Part Number:	D3243-1
Inspection Dwg: D3243 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
11.920	+/-0.010	11.920	2	,,,,	7	
11.420	+/-0.010	11.420	2		1	
Ø0.201	+0.005/-0.000	106,	2		1/	-
Ø0.290	+0.005/-0.000	1	>		V	
1.375	+/-0.005	1.373	2		V	
5.273	+/-0.010	5.771	+		V	
0.500	+/-0.010	-501	h		V	
0.500	+/-0.010	-505	3		V	
0.750	+/-0.010	,748	2_		V	
R0.50	+/-0.030	,50	2		R.G	<u> </u>
5.360	+/-0.010	5.363	7		V	14.11.
5.810	+/-0.010	5.816	2		V	
6.560	+/-0.010	6.556	2		1,	
R0.250	+/-0.030	DX.	7		Ř.G.	No.

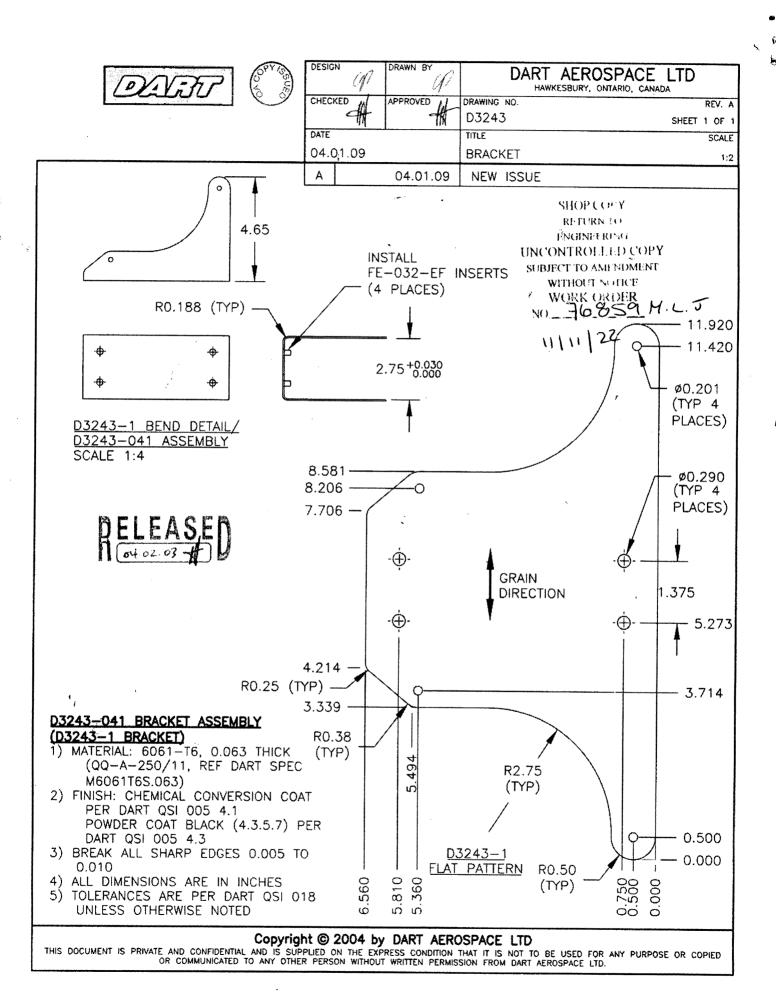
			\sim		
Measured by:	B	Audited by:	7	Prototype Approval:	N/A
Date:	11-12-17	Date:	4112 13	Date:	N/A

Rev	Date	Change	Revised by	Approved
`A	04.02.18	New Issue (P/O D044-715-011)	KJ/JLM ,	
В	04.04.19	Removed dimensions from FAI	KJ/RF	-14
			·	

Dart Aerospace L	Ltd
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W/O:			W	ORK ORDER CH	ANGES						
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
							•				
Part No	•	PAR #:	Fault Cate	gory:	NC	R: Yes	No DQ	A:	_ Date: _		
Resolution:		Dispositio	n:	QA	QA: N/C Closed:				Date:		
NCR:			WORK ORD	ER NON-CONFO	PRMANCE	(NCF	₹)				
DATE	STEP	Description of NC		Corrective Action Section		Verilication			Approval	Approval	
DATE	SIEF	Section A	Initial Chief Eng	Action Descrip Chief Eng	otion 	Sign 8		on C	Chief Eng	QC Inspector	
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Dart Ae	rospace	e Ltd							
W/O:			WC	RK ORDER CHANGE	S				
DATE	STEP	PRO	CEDURE CHAI	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto	
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		:							
Part No: PAR #:		Fault Cate	jory:	NCR: Yes No DQA: Date:					
	R	esolution:	Disposition	1:	QA: N/C C	losed:	Date: _		
NCR:		V	VORK ORDE	R NON-CONFORMAN	NCE (NCI	₹)		-	
		Description of NC	Corrective Action Section B			Verification	Approval	Approval	
DATE	STEP	STEP Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Section C	Chief Eng	QC Inspecto	
							•		